

Ship Subject SLIT

Dart Aerospace Ltd.

Date: Thursday, 6/29/2006 3:52:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 27792		
Estimate Number	: 10779		
P.O. Number	: <u>NIA</u>	Part Number	: D3463041
This Issue	: 6/29/2006	S.O. No.	: <u>NIA</u>
Prsht Rev.	: NC	Drawing Number	: D3463 REV.B
First Issue	: <u>NIA</u>	Project Number	: N/A
Previous Run	: 24917	Drawing Revision	: A
		Material	: <u>NIA</u>
Written By	: <u>SEA</u>	Due Date	: 7/12/2006
Checked & Approved By	: <u>060629</u>	Qty:	4 Um: EACH
Comment	: EST REV. A 05.11.18 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	238806	SS DOWEL PIN 1" LONG
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	238-806	SS DOWEL PIN 1" LONG	<u>M19080</u>

PD 06-07-20 (4)

2.0	D34533	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3453-3	Clevis	<u>B21102 -> 1</u>

B21199 -> 3

PD 06-07-20 (4)

3.0	D34637	Drag Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-7	Drag Arm	<u>B21536 -> 2</u>

PD 06-07-20 (4)

4.0	D34631	Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3463-1	Arm	<u>B21802 -> 2</u>

B21534 -> 2

PD 06-07-20 (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27792

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3463-3

Step

B21535

PD

06-07-20 (4)

6.0

D34635F

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3463-5F

Step Flat Pattern

B21853

PD

06-07-20 (4)

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3453-5

Plug

B21800

PD

06-07-20 (4)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463

PD

06-07-20 (4)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

J / M 06/07/20 (4)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

a.m 06/07/20 (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27792

Part Number: D3463041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

DU 06/07/21 (4)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

U 06-07-21 (1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

U 06-07-21

Job Completion



U 06-07-21

